Work Order . Friday, May 16, 201		5. 1	*119	9521*	i Hy	N.				Page 1
Revision ID:	inless Steel Wearplate Fwd	Sple	Accept	*N900	040	100)* s	Setup Star	1.0	S1*
Start Date: 5/1 Required Date: 5/1 Reference:	5/14 Start Qty: 12.00 5/14 Req'd Qty: 12.00	*12* *12*		Cust Item ! Customer:	ID:					1
Approvals: Pr	rocess Plan: 」	Date: \\\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \	Tooling: SPC (Y/N):		ate:		R	Run Star Stop	.1/1	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						13			
D3564	Rev D									
*100 *100* Waterjet	FLOW WATER JET Memo		0.00	1		Ž.	13	0		Jm14-05-2
ELOW CNC Waterjet	1-Cut as per Rev:	Dwg D3564 ******(D356- 2-Deburr if necessary	4-1F)*****Dwg Rev:_	Prog						
110	QC2- Inspect parts off m	achine FAI/FAIB	0.00				12			
110 ec	Memo		0.00				13	0		Jm14-05-
Quality Control			* ==7	DAS						
120	QC8- Inspect parts - sec	ond check	0.00	27 9-89	Ž.		13			
Q::ality Control	Memo		0.00 MIS	126					-	

DQA:			Date:										DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT	ΓE			AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AG	GAINST DE	PARTMENT	PROCESS	
TTOIN OTAL					_	Rework	ıl		Skid-tube Cro	sstube]	Water Jet	Engineering
Part N	lo.					Scrap			SECTION OF THE PROPERTY AND THE PROPERTY OF TH	nall Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming Fir	nishing	Rec/Stor	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Com	nposite]	Supplier	
Root					Desci	ription of work order update	Н	Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	1	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator		_											
Offset/Setup													
Process													
Supplier													
Training		i i											
Transport													
Unapproved													
6.2							FA	ULT CA	TEGORY				
Landi	ng (1				General	_	1			T= 80 90		7
		Bending				Bend			Program	_	Outside Dim	_	Pressure/Forced
		Centre No	ot Concer	tric	_	BOM/Route		Grain		_	Over/Under		Set-up
	_	Cracks			_	Broken/Damage/Defect		Hardwa			Part Incorred	_	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs			ion Incomplete/Unqualifi		Part Lost/Mi	100	Weld
		Cuffs			_	Contamination			tions Incomplete/Unclear	r	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		-	gned/off center		Positioned V		7
	_	Heat Trea				Cut Too Short		Mislabe			Power Loss/	Surge	Other
	_	Inspectio		Tube		Drawing		Misrea					
	_	Marks/Ch				Drill Holes		Off-set					
	_	Turning S				Finish		-	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Work Order ID 119521

119521

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Friday, May 16,	2014 1:00:4	40 PM		1 1.2	1. 12 1	The state of the s	2014	tell her	I die	
Item ID:	D3564-9		¥	Accept	*N900	040100)* s	Setup Start	*N	S1*
Revision ID:								Stop		
Item Name:	Stainless Stee	l Wearplate Fwd						Stop	*//:	S2*
Start Date:	5/15/14	Start Qty: 12.00	*12*		Cust Item I	D:	-			
Required Date:	5/15/14	Req'd Qty: 12.00	*12*		Customer:					
Reference:			17							
Approvals:	Process Pla	in:	Date:	Tooling:	D:	ate:	R	tun Start	~ IV	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:		Stop	*N	R2*
Sequence ID/		Operation		Set Up/	Tool ID	Tool # Plan	Accept	Reject	Reject	Insp.
Work Center II	J	Description		Run Hours		Code	Qty	Qty	Number	Stamp
		NC BRAKE		0.00		DAS				14/05
130 Brake NC				0.00		30	_13_			
Brake NC			essaryForm on Brake as pen n Joggle as per Dwg D356	er Dwg D3564 using Jigs 4 on brake using Jig DT		9-89				
T40		OCS Investment			27					
		QC5- Inspect part comple	teness to step on w/O	0.00	9-89		13			
140		N. FLODO		0.00	3613		1)			
Quality Control		Memo Ensure joggle	e as per dwg D3429	0.00						
150		Large Fab		0.00				111	- 4	-
150				0.00				14-	06-0	2 mg
Large Fab		Memo M (2226)	ription Batch Weld hardcoat as per Dwg	0.00 A/R 2059B Hard D3564	coat					
		and the								

DQA:	3	Date:										DART
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date:							Wo	rk Order up	date only	
Work Order	:		4		DISPOSITION			AGAINST	DEP	ARTMENT/	PROCESS	
Part No)				Rework Scrap Use-as-is		2.2	Skid-tube Crosstube Machining Small Fab moforming Finishing			Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR No)			_	Suspected Unapproved			Large Fab Composite	-	,	Supplier	
Root	11.0		-	Desci	ription of work order update	ı	nitial	Action	T	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	****	*	4.3		24L 100 3 E							
опоррготса						FAI	ULT CA	TEGORY				
Landing	g Gear				General							
	Bending	ot Conce	ntric		Bend BOM/Route Broken/Damage/Defect		Folio/F Grain Hardwa	Program		Outside Dime Over/Under Part Incorrec	tolerance	Pressure/Forced Set-up Temperature/Cure
-	_	nk/Ripple	ΛΝανο	-	Burrs	-	N 10 Perfusion Cross	tion Incomplete/Unqualified	-	Part Lost/Mi	_	Weld
	Cuffs	int/mphic	, wave	-	Contamination			tions Incomplete/Unclear	-	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		4	gned/off center	\vdash	Positioned W	/rong	
	Heat Tre				Cut Too Short		Mislab		-	Power Loss/S		Other
	\dashv	n Strip in	Tube		Drawing		Misrea		ш			
	Marks/C		the state of		Drill Holes		Off-set		-			
	_	Sequence			Finish		1	Calibration	-			
	—	vist in Tu			Fit/Function		-	Sequence				

Work Order ID 119521

119521

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Friday, May 16,	2014 1:00:4	10 PM			1:1/ [1			and the		- Luger
Item ID: Revision ID: Item Name:	D3564-9 Stainless Stee	l Wearplate Fwd		Accept	*N900	040	100)* s	Setup Sta	1.0	S1*
	5/15/14	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item 1 Customer:	ID:				IV.	27
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Sta) ^ [V]	R1*
Sequence ID/ Work Center II :60 *160* QC Duality Control		Operation Description QC10- Inspect visual per Memo QC5- Inspect part comple		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Insp. Stamp
180 *180* Powdercoat Powder Coating		Grey Sandtex(Ref:4.3.5.0	2.7v	0.00 0.00 OVEN TEMPERATURI	3:			1 0	8 pr	1.6-	2. 88

DQA:			Date:										DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS	
	3.5				_	Rework	1		Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	AP N				-	Use-as-is		Thern	noforming Finishing		Rec/Stor	re/Packaging	Other
NCR N	10.				_	Suspected Unapproved			Large Fab Composite]	Supplier	
Root					Desci	ription of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport	645												
Unapproved													
							FAI	ULT CA	TEGORY				
Landi						General		1		_	1	200	7.
		Bending				Bend			Program	\vdash	Outside Dim		Pressure/Forced
- 5.2		Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	Construction and the construction of the const	Set-up
= 60.5		Cracks				Broken/Damage/Defect		Hardwa		⊢	Part Incorred	_	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		4	tions Incomplete/Unclear	\vdash	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink	_	1	gned/off center	L	Positioned V		7
		Heat Trea				Cut Too Short		Mislabe		L	Power Loss/	Surge	Other
		Inspection		Tube		Drawing		Misrea					
		Marks/Ch				Drill Holes		Off-set					
		Turning S				Finish		-	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

Work Order ID 119521

119521

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Friday, May 16	6, 2014 1:00:	40 PM		115	10/10	28 6		Tage 4
Item ID: Revision ID: Item Name:	D3564-9	el Wearplate Fwd		Accept	*N900	040100		art *NS1*
		.5	44 04		50,000 70,000	200		・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・
Start Date: Required Date	5/15/14	Start Qty: 12.00 Req'd Qty: 12.00	*12*		Cust Item	ID:		
Reference:	. 5/15/14	Keq u Qty. 12.00	*12*		Customer:			
Kelerence.							Run St	art +NID4+
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:		"INHI"
	QC:		Date:	SPC (Y/N):	D	ate:	St	° *NR2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Teol ID	Tool# Plan Code	Accept Reject Qty Qty	Reject Insp. Number Stamp
190		QC3- Inspect Part Finish		0.00				
190 QC Quality Control		Мето		0.00			D H 06	02 10
200		Identify as per dwg & Sto	ock Location:	0.00				1
200 Packaging Packaging		Memo	PPP/1981	0.00			17/4/2	06
2:0		QC21- Final Inspection -	Work Order Release	0.00				
210		Memo		0.00			MC9 1	106-03
Quality Control								MF _{y-6-0}

DQA:			Date:										DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	era					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
24428441202284414						Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part N	10.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
						Use-as-is			noforming Finishing		Rec/Stor	e/Packaging	Other
NCR N	10.				_	Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desc	ription of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	1.5	or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	_												
Handling/Pre													
Material	_												
Operator	_												
Offset/Setup	_												
Process													
Supplier													
Training	_												
Transport	-								-				
Unapproved		ļ <u> </u>					EΔI	IIIT CAT	TEGORY				
Landi	ng (Sear		V		General	IA	OLI CA	ILOOKI	_			
Lanui	15	Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	tric	-	BOM/Route	\vdash	Grain	108.411		Over/Under	_	Set-up
		Cracks		1811.00		Broken/Damage/Defect		Hardwa	are		Part Incorred	NAME OF TAXABLE PARTY O	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		100000000000000000000000000000000000000	ion Incomplete/Unqualified		Part Lost/Mi	-	Weld
		Cuffs				Contamination		-	tions Incomplete/Unclear	Г	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		-1	gned/off center	Г	Positioned V	ALC: A CONTRACT OF THE PARTY OF	
		Heat Trea	it			Cut Too Short		Mislabe	COMPANY STATE OF THE STATE OF T		Power Loss/		Other
		Inspection		Tube		Drawing		Misread	d	_			
		Marks/Ch				Drill Holes		Off-set					
		Turning S	equence			Finish		Out of (Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Friday, May 16, 2014 1:00:44 PM

Work Order ID: 119521

119521

Parent Item:

D3564-9

D3564-9

Parent Item Name: Stainless Steel Wearplate Fwd

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty -	Date Issued	Status
M304S16GA		Purchased	No			100	sf	300.7670	1.41	18			- 61
M304S16	3GA								**			JN	114-05-7

304/316 Sheet .063

Lo	cation	Loc Oty	Loc Code	
M.	AT020	300.767		500 St. J
	M127821	75.567		W.
	M128423	1.2		
	M129192	224		139192

DQA:			Date:										DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:			200 200 200 200			GR0	W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
					-	Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
0.247.757.0	19					Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging	Other
NCR N	ю.				_	Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data	Ť.	100										14	
Equip/Tooling													
Handling/Pre		120											
Material													
Operator													
Offset/Setup				- 5	5								
Process													
Supplier													
Training													
Transport													
Unapproved								= 0.1	TTOODY.	_			
							FAI	ULI CA	TEGORY				
Landi	ng (1				General		11:-/	lea aram		Outside Dim	onsions [Pressure/Forced
		Bending		O 4 (7.4°)	-	Bend BOM/Bouts	\vdash	Grain	Program	\vdash	Over/Under		Set-up
	_	Centre No	ot Concer	itric	-	BOM/Route	\vdash	-		-	Part Incorre		Temperature/Cure
		Cracks	1./0:1-	hat	-	Broken/Damage/Defect	_	Hardwa	ion Incomplete/Unqualified	-	Part Lost/Mi	_	Weld
	_	Crimp/Kir	ік/кірріе	/wave	-	Burrs		In manual contract	West Transport of the Park of March 2011	\vdash	Part Moved	551118	Wrong Stock Pulled
	-	Cuffs				Countarink	-	-1	tions Incomplete/Unclear gned/off center	-	Positioned V	Vrong	_ who his stock i dired
	_	Crushing				Countersink Cut Too Short	_	Mislabe		-	Power Loss/		Other
		Heat Trea		Tubo	-	Drawing	-	Misrea			J. 0 W.C. 1.033/		- The state of the
	_	Inspectio Marks/Ch		Tube	-	Drill Holes	-	Off-set					
		Turning S			-	Finish	-	-	Calibration		(d 		
		Wave/Tw				Fit/Function		-	Sequence)!		
		wave/ IW	ist iii iub)C		i it/ i unction	1	Out of	Jegaenee				

DART AEROSPACE LTD	Work Order:	119521
Description: Wearshoe	Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
	FIRST AFTICIE	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.227"			V	Jamos
2.432	+/-0.010	2.435	-		V	
2.50	+/-0.030	2.50	-		V	
6.000	+/-0.010	6.003"	-		V	
12.104	+/-0.010	12.104"	_		Т	JEM07
18.000	+/-0.010	18.000	-		T	
18.000	+/-0.010	18.000	-		T	
18.00	+/-0.030	18-00"	-		T	
9.00	+/-0.030	9.004	_		V	JEM08
11.50	+/-0.030	11:502"	-		V	
0.300 x 0.300	+/-0.010	0.303' x0302"	-		V	
Ø0.188	+0.005/-0.001	0.189"	-		V	
R0.375	+/-0.010	0.375	_		RG	
0.063	+/-0.010	0.060"	_		٧	
			DAS			

Measured by:	Jm	Audited by:	9-89	Prototype Approval:	N/A
Date:	14-05-24	Date:	14/5/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.01.16	New Issue	Revised by KJ/EC/DD	N N





